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K6A 1K7
Canada

Tel (613) 632-5200

Reprint
D206-642-311BL
Job Sheet 166714-C



Part No: D206-642-311BL

Job Qty: 1 ea

Part Name: Skidtube LH (Ael Blue)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 11/27/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Air Evac Lifeteam (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O (*AEL*), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: DWG REV Q SHEETS 29-30 IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M as per REV.N DD 10.04.19 verified by:EC IPP Rev:N 14.04.25 ECN14-520 DD verf:JLM IPP REV:O 15.10.09 ADDED BL DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/27/17	0.00	0.00	Start Up Stores/Pkg-1		
100	DC	1 pcs		11/27/17	0.00	0.00	DC		
110	Packaging	1 pcs		11/27/17	0.00	0.00	Packaging1		
120	QC	1 pcs		11/27/17	0.00	0.00	QC4		
130	Packaging	1 pcs		11/27/17	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		11/27/17	0.00	0.00	QC21		

Part Op 100 - Document Control Photocopy bluefile and create labels per PPP D206-642-311 CHG008

Descriptions: 110 - Pick Kit

120 - QC4- 100% Inspect kits for completeness

130 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-311 Location:

PPP Rev: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3-41A <i>5015003</i>	8	33	0	0
	- AN4-6A <i>5013754</i>	12	449	0	0
	- AN4C5A <i>5013753</i>	1	31	0	0
	- AN5-10A <i>5013752</i>	4	155	0	0
	- AN5-11A <i>5013751</i>	8	440	0	0
	- AN5-12A <i>5013750</i>	4	496	0	0
	D206-642-341BL	1	19	0	0
	D206-648-013BL	1	2	0	0
	- D2652 <i>5013749</i>	16	340	0	0
	- D2712 <i>5013740</i>	10	93	0	0
	- D2932-1BL <i>5014251</i>	1	1	0	0
	- D2933-1BL <i>5014440</i>	1	1	0	0
	- D2934 <i>5013746</i>	2	28	0	0
	- D2935 <i>5013745</i>	2	48	0	0
	- D2938-1BL <i>5014438</i>	1	1	0	0
	- D2939-1BL <i>5014439</i>	1	1	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DIS Suspected		AGAINST DEPARTMENT/PROCESS S015743 Skidtube LH (Ael Blue) PART NO: Revision: Operation: Change No:		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Water Jet</td> <td style="width:33%;">☐</td> <td style="width:33%;">Engineering</td> <td style="width:33%;">☐</td> </tr> <tr> <td>Prod. Eng. Coord.</td> <td>☐</td> <td>Quality</td> <td>☐</td> </tr> <tr> <td>Rec/Store/Packaging</td> <td>☐</td> <td>Other</td> <td>☐</td> </tr> <tr> <td>Supplier</td> <td>☐</td> <td></td> <td></td> </tr> </table>		Water Jet	☐	Engineering	☐	Prod. Eng. Coord.	☐	Quality	☐	Rec/Store/Packaging	☐	Other	☐	Supplier	☐		
Water Jet	☐	Engineering	☐																				
Prod. Eng. Coord.	☐	Quality	☐																				
Rec/Store/Packaging	☐	Other	☐																				
Supplier	☐																						
Date : _____		Step #: _____		D206-642-311BL Start up Operation Mfg Date: 11/30/17 Job No: 166714-C		MRB (QSI042) Approval																	
Description Work Order Deviation		Completed By																					
		Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																			

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/I	☐	Wave/Twist in Tube	☐
Bending	☐	Marks/Chatter	☐
Centre Nc	☐		
Cracks	☐		
Crimp/Kir	☐		
Cuffs	☐		
Crushing	☐		
Heat Treas	☐		
OTHER :	☐		

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Power Loss/Surge
 Folio/Program
 Grain
 Weld
 Wrong Stock Pulled
 Out of Sequence
 Off-set
 Misabeled
 Fit/Function
 Misaligned/off center

Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

- D3407-043	SOI3747	1	✓	29	0	0
- D3413-1	SOI4249	1	✓	47	0	0
- D3456-1	SOI3744	1	✓	69	0	0
- D3457-1	SP15601	2		14	0	0
- MS21042L3	SOI3743	8	✓	1,029	0	0
- MS21042L4		12		1,019	0	0
- MS21043-4	SOI3741	1	✓	813	0	0
- NAS1149C0463R	SOI3740	1	✓	119	0	0
- NAS1149D0363J	SOI3740	8	✓	247	0	0
- NAS1149D0463J	SOI5002	26	✓	527	0	0
- NAS1149D0563J	SOI3739	8	✓	1,238	0	0

Part Specifications

Specifications could not be found.

Plex 11/20/17 3:27 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																